

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004014**Date Inspected:** 08-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang / Tian Jian Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** skin plate assembly, deck plate**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 60 ZPMC workers performing the following: flame heat straightening and flame cutting of beveled edge on plates; electric preheat in preparation for SAW of SSD1-SA108 skin plate and NSD1-SA10 skin plate; FCAW-G of stiffener to SSD1 – skin E assembly in the tilted up position. Also present in this bay were ZPMC CWI Liu Yang as well as ABF QC's Yang Yi Heng, Liu Cheng, and Zhang Qin Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 45 ZPMC workers performing the following: grinding of temporary tacks used for fitting on tops of stiffeners on ESD1 – skin E; FCAW-G - automatic with gantry of stiffener to ESD1 – skin D. Also present in this bay were ZPMC CWI Tian Jian Fei and ABF QC Zhang Da Ming. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed 12 ZPMC workers performing the following: UT of U-rib to deck plate welds on DP562-001; grinding of U-rib to deck panel welds on DP586-002 and DP560-001. There were 19 full size panels and 2 half size panels present in the bay. Also present in this bay were ABF QC's Wang Zhong Yuan and Ding Bao Hua. Items observed appeared to comply with project specification.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer